

Date: Tuesday, 7/24/2007 10:43:48 AM  
 User: Jean-Luc Menard

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STIFFNER
Job Number : 33719	
Estimate Number : 12955	
P.O. Number :	Part Number : D36391
This Issue : 7/24/2007 S.O. No. :	Drawing Number : D3639 UNDER REVIEW
Prsht Rev. : NC	Project Number : AC0005
First Issue : 7/24/2007 Type : SMALL /MED FAB	Drawing Revision : U/R
Previous Run :	Material :
Written By : <u>LM 07-07-24</u>	Due Date : 7/31/2007 Qty: 2 Um: Each
Checked & Approved By :	
Comment : Est Rev:A New Issue 07-07-20 JLM	Verified By:EC

Additional Product

**PROTOTYPE**

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S050	2024-T3 .050 sheet
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Comment: Qty.: 0.2510 sf(s)/Unit Total : 0.5019 sf(s)

2024-T3 .050 sheet

Batch: M103321 HB 07-07-30

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3639

Dwg Rev: PROTOProg Rev: TYPEHB 07-07-30

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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HB 07-07-30

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

C'sink as per Dwg D3639

HB 070731(2)

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STIFFNER

Job Number: 33719

Part Number: D36391

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3639

**ENGINEERING  
APPROVAL**

VE 07-08-08

070731

②

7.0

QC5



Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

N/A

9.0

QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: \_\_\_\_\_

VE 07-08-08

11.0

QC21



FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/08/15

Job Completion



FOR ENGINEERING USE ONLY

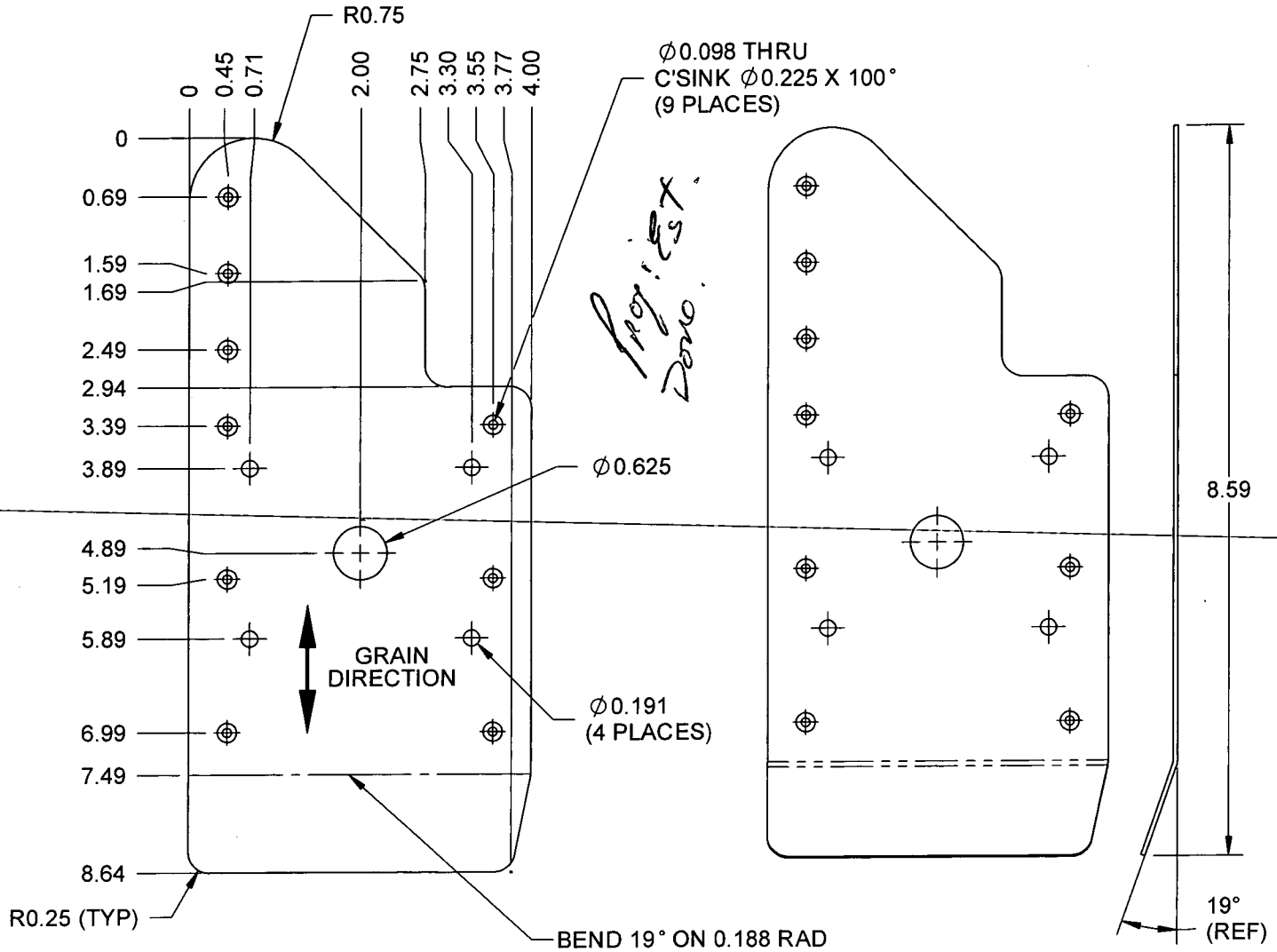
W/O 00104

U 07-08-05

**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING

LE 07.07.17

DESIGN TS	DRAWN BY LE	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED	DRAWING NO. D3639	REV. A SHEET 1 OF 2
DATE 07.06.25	TITLE STIFFENER		
REV A	DATE 07.06.25	DESCRIPTION NEW ISSUE; REPLACES G10604	



**D3639-1F FLAT PATTERN**  
**(D3639-2F OPPOSITE)**

**D3639-1 STIFFENER**  
**(WAS GENEVA P/N G10604-3)**  
**D3639-2 OPPOSITE**  
**(WAS GENEVA P/N G10604-6)**

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037  
(REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3639-1/-2" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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DART AEROSPACE LTD		Work Order: 33719
Description: STIFFNER		Part Number: D3639-1
Inspection Dwg:	Rev: PROTOTYPE	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.69	+/- .030	.69	*			
1.59	+/- .030	1.59	*			
1.69	+/- .030	1.69	*			
2.49	+/- .030	2.49	*			
2.94	+/- .030	2.94	*			
3.39	+/- .030	3.39	*			
3.89	+/- .030	3.89	*			
4.89	+/- .030	4.89	*			
5.19	+/- .030	5.19	*			
5.89	+/- .030	5.89	*			
6.99	+/- .030	6.99	*			
7.49	+/- .030	7.49	*			
8.64	+/- .030	8.64	*			
.45	+/- .030	.45	*			
.71	+/- .030	.71	*			
2.00	+/- .030	2.00	*			
2.75	+/- .030	2.75	*			
3.30	+/- .030	3.30	*			
3.55	+/- .030	3.55	*			
3.77	+/- .030	3.77	*			
4.00	+/- .030	4.00	*			
Ø .098	+ .004 - .001	.099	*			
Ø .191	+ .005 - .001	.192	*			
Ø .625	+ .008 - .001	.626	*			

Measured by: <u>UB</u>	Audited by: _____	Prototype Approval: <u>UE</u>
Date: <u>07-07-30</u>	Date: _____	Date: <u>07.08.08</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	